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Push

D4436-049
Job Sheet 186356



Part No: D4436-049

Job Qty: 2 ea

Part Name: Aft Outboard Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4436 REV.B IPP REV:A 18.11.13 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs		11/30/18	0.00	0.30	Waterjet - Flow		<i>SC 18/11/29</i>
110	QC	2 pcs		11/30/18	0.00	0.00	QC2 Waterjet-3		<i>SC 18/11/29</i>
120	QC	2 pcs		11/30/18	0.00	0.00	QC8-4		<i>38</i>
130	Brake NC	2 pcs		11/30/18	0.06	0.17	Brake NC 2		<i>9-89</i>
140	Small Fab	2 pcs		11/30/18	0.00	0.23	Small Fab-6		<i>DAS</i>
150	QC	2 pcs		11/30/18	0.00	0.00	QC5		<i>38</i>
160	HandFinish	2 pcs		11/30/18	0.00	0.23	HandFinish1		<i>D.R 18/12/15</i>
170	QC	2 pcs		11/30/18	0.00	0.00	QC7-3		<i>38</i>
180	Small Fab	2 pcs		11/30/18	0.00	0.23	Small Fab-6		<i>DAS</i>
185	QC	2 pcs		11/30/18	0.00	0.00	QC5		<i>DEC 05 2018</i>
190	Powdercoat	2 pcs		11/30/18	0.00	0.10	Powdercoat4		<i>18-12-06</i>
200	QC	2 pcs		11/30/18	0.00	0.00	QC3		<i>Smf</i>
202	Small Fab	2 pcs		11/30/18	0.00	0.23	Small Fab-6		<i>Smf</i>
205	QC	2 pcs		11/30/18	0.00	0.00	QC5		<i>38</i>
210	Packaging	2 pcs		11/30/18	0.00	0.00	Packaging3-2		<i>DAS</i>
220	QC21-SA	2 Ea		11/30/18	0.00	0.00	QC21		<i>21 DEC 06 2018</i>

Part Op 100 - 1-Cut D4436-9 as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary 9-89

Descriptions: 140 - C"SINK AS PER DWG

180 - Assemble as per dwg. do not install rubber seal.

190 - START TIME: 8:45 OVEN TEMPERATURE: 320° FINISH TIME: 9:15 11/38539.

202 - Cut and Install rubber seal as per dwg 3M 1300 batch: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	3.1800 sf (1.59 ea)	100-Waterjet - Flow - 1	<i>5120084</i>
MS20426AD3-2	Rivet	8 Ea (4 ea)	180-Small Fab	<i>5018535</i>
MS21075L08	Anchor Nut	4 Ea (2 ea)	180-Small Fab	<i>5123462</i>
D4441-1	Rubber Seal	2.8160 ft (1.408 ea)	202-Small Fab	<i>509267</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	3	230	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use ☐ Susp ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Cross tube Small Fah ☐ Water Jet ☐ Engineering Quality Other ☐	
Date : _____		Step #: _____		(QSI042) Approval Completed By _____ and / Supervisor Approval Verification _____ QA Coordinator Approval _____	
Description Work Order Deviat					
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due Pressure/Fc Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter OTHER : BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Conditioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence					

DART AEROSPACE
Container No: S133219
Part: D436 - 049
Job No: 186356
Serial No/Batch: S133219
Revision: B
Inspector:
Exp Date:
Instructions: Various STC's
Date: 11/29/18
Dart Aerospace Ltd.
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Hawkebury, ON K0A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

180-Small Fab	MS20426AD3-2	8	18,539	0
	MS21075L08	4	77	0
202-Small Fab	D4441-1	3	539	0

Part Specifications

Specifications could not be found.

Plex 11/14/18 1:35 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

